

Work Order ID 83069-2

Split 2/2

83069

Page 1

April-12-12 4:07:40 PM

Item ID: D3565-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate

Start Date: 12/04/2012 Start Qty: 9.00

9

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 9.00

9

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: ML5

Date: 12/04/13

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					(10)			
D3565	Rev C1								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3565 Dwg Rev: C Prog Rev: C-2
Deburr if necessary

364.062

B12-5-24

110

QC2- Inspect parts off machine.FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-5-24

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8/12/12

(10)



8

8.3069

April-12-12 4:07:40 PM

N900040100

Setup Start *NS1*

Stop *NS2*

9

Cust Item ID:

9

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Insp.
Stamp

0.00

160

Powdercoat

Powder Coating

Memo

0.00

START TIME:

14h30

OVEN TEMPERATURE:

320° FINISH TIME:

12h00

m122966

85 Q. (2P) 13/03/06

0.00

170

QC

Quality Control

Memo

0.00

YS of all 13/02/06

Identify as per dwg & Stock Location: ST 500

0.00

180

Packaging

Packaging

Memo

0.00

5x Sp
13-3-8



Work Order ID 83069

April-12-12 4:07:40 PM

83069

Page 4

Item ID: D3565-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate

Start Date: 12/04/2012 Start Qty: 9.00

9

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 9.00

9

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

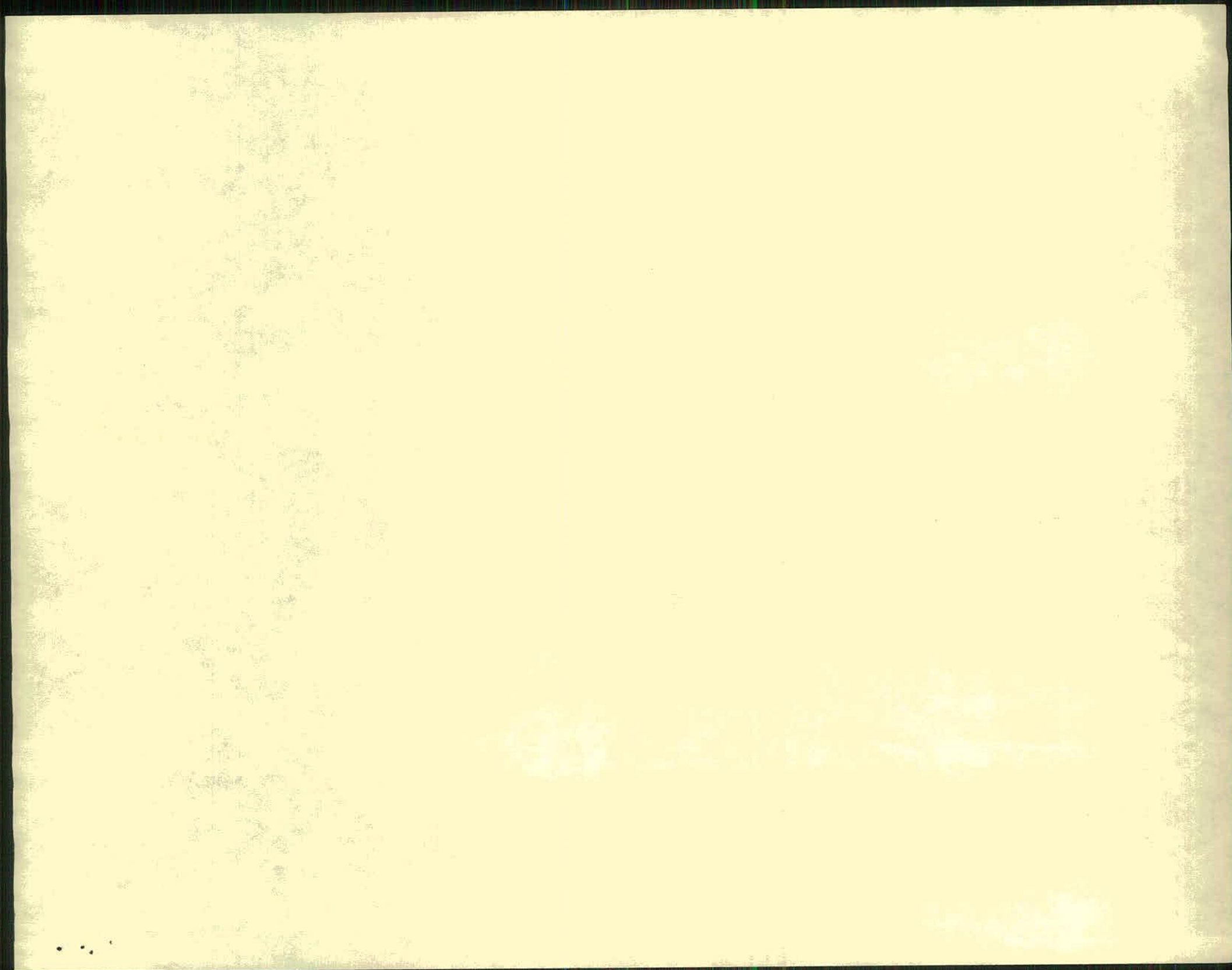
Memo

0.00

Quality Control

MLJ 13-03-08

MLJ 13-03-08



Picklist Print

April-12-12 4:07:44 PM

Page 1

Work Order ID: 83069

83069

Parent Item: D3565-1

D3565-1

Parent Item Name: Wearplate

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 9.00

Required Qty: 9.00

Comments: IPP Rev :A New Issue 07-01-16 JLM
 IPP rev B revB dwg 07.04.18 ec
 IPP Rev:C rev.c as per dwg 08-01-14 DD verified by:
 IPP Rev: D QC5 added to step 8 08.12.22 KJ Verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3009-3		Manufactured	No			100	Each	32.0000	3	27			
---------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D3009-3

Cup

**

Location

Loc Qty

Loc Code

WA

79078

80095

93296

30

2

M304S16GA

Purchased

No

130

sf

239.8520

0.135

1.278947

M304S16GA

304/316 Sheet .063

**

Location

Loc Qty

Loc Code

MAT020

120866

120877

121070

239.852

38.446

137.326

64.08

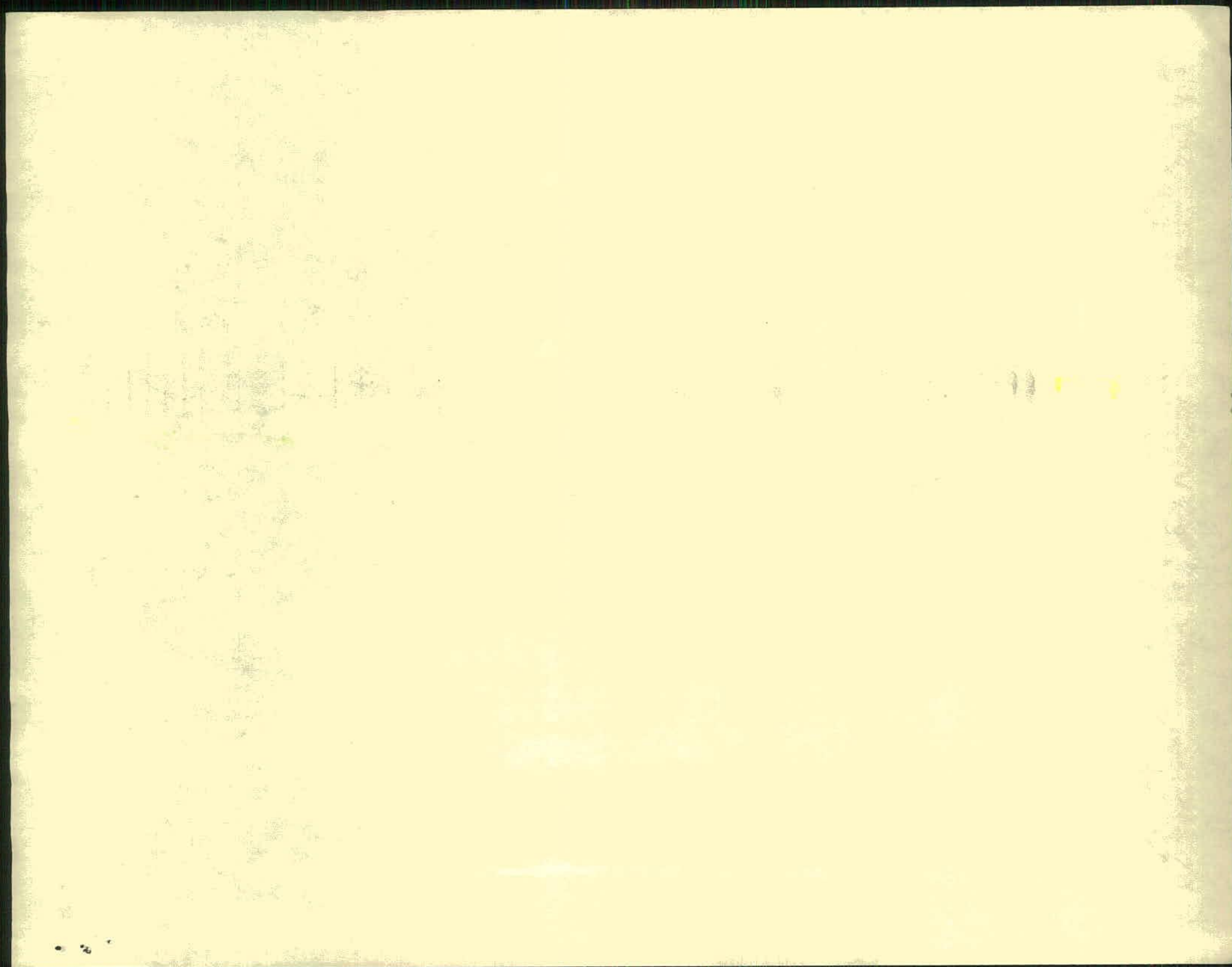
121626

13-03-04

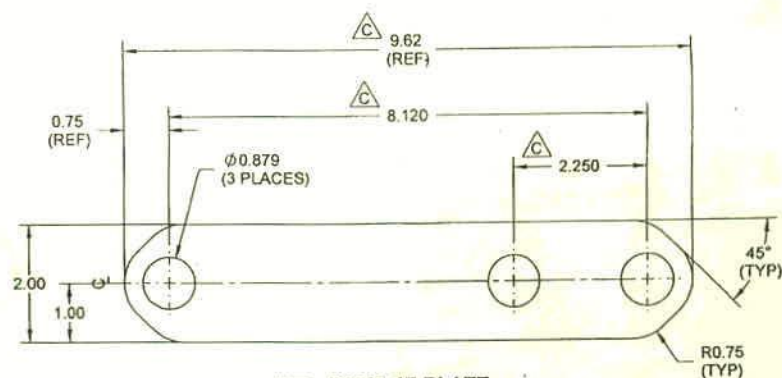
1312-5-24

10

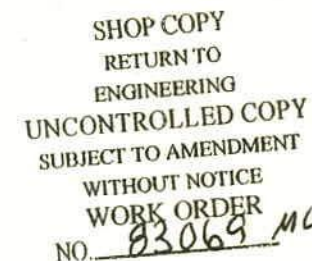
121626







 **D3565-1F PLATE**



RELEASED
66-51-11

QTY -1	P/N	DESCRIPTION
X	D355-1	R44 WEARPLATE
1	D355-1r	PLATE
3	D355-3	CUP

NOTES:

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S16GA)
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3565-1" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.38 lbs
 - 8) WELD PER DART QSI 004
 - 9) PART IS SYMMETRIC ABOUT C

PLATE NOW WELDED (07.12.14) WAS 8.120; 1.250 VAS 2.300 (D2; ADDED PARTS LIST (07); UPDATED NOTES (A-)		MO	07.12.14
C	8.270 WAS 8.120; 2.300 WAS 2.250; ADD HOLE DIMS AFTER CUP FORMING	CB	07.03.12
B	NEW ISSUE	CB	07.01.09
A		BY	DATE
REV.	DESCRIPTION		
DESIGN	 DART AEROSPACE LTD HAWKESSBURY, ONTARIO, CANADA		
DRAWN	DRAWING NO.		REV. 0
CHECKED	D3565		SHEET 1 OF 1
MFG. APPR.	TITLE		SCALE
APPROVED	R44 WEARPLATE		1:
DE APPR.	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. UNLESS AUTHORIZED BY THE EXPRESS CONSENT OF THE USER, NO REPRODUCTION OR COPIES OR COMMUNICATIONS TO ANY OTHER PERSON OR ENTITY IS PERMITTED.		
DATE	07.12.14		

